

Job Number: 40608

Part Number: PB674300115

Job Number:

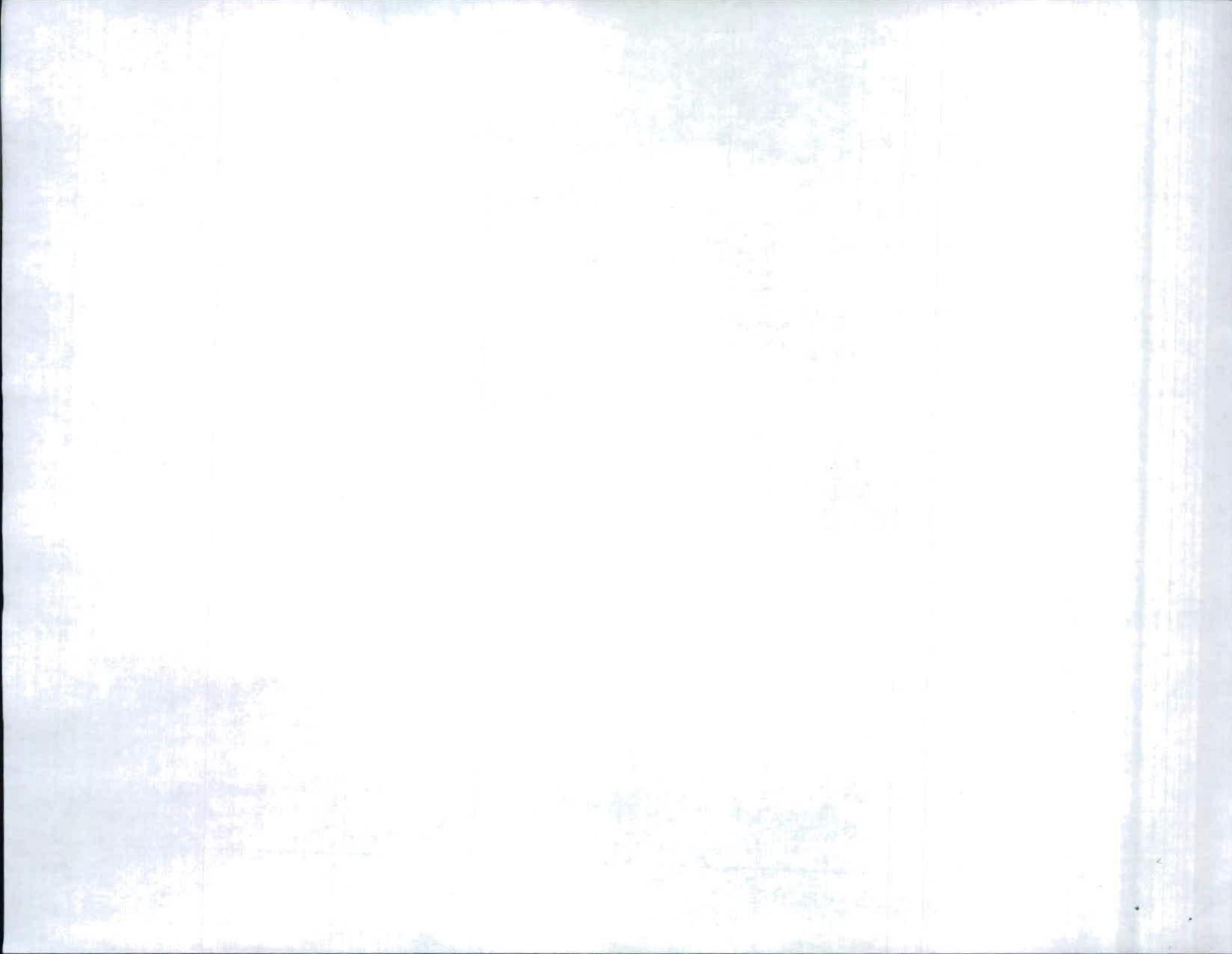


| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|------------------------------|
| 20.0 | QC5 | INSPECT WORK TO CURRENT STEP |
| 21.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| 22.0 | QC21 | FINAL INSPECTION/W/O RELEASE |

S09/09/12*8/9/12 ax SP**08/09/15 dff**MF 08-09-12*

Job Completion





Process Sheet

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Customer: CU-DAR001 Dart Helicopters Services

Part Number: PB674300115

Job Number: 40608

Job Number:



Seq. #:

Machine Or Operation:

Description:

(30)

START TIME:

1:40

OVEN TEMPERATURE:

320

FINISH TIME:

2:10

m/h

08/07/31

14.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/07/31

6

15.0 PB674300173



20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

20 Degree Cover Plate

batch: 40094

K 08-08-26

16.0 PB674300183



PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

PB67-43001-83

batch: 40096

K 08-08-26

17.0 MS27039110



Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Screw

batch: 108986

K 08-08-26

18.0 NAS1149F0316P



WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

WASHER

batch: 108473

K 08-08-26

19.0 SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



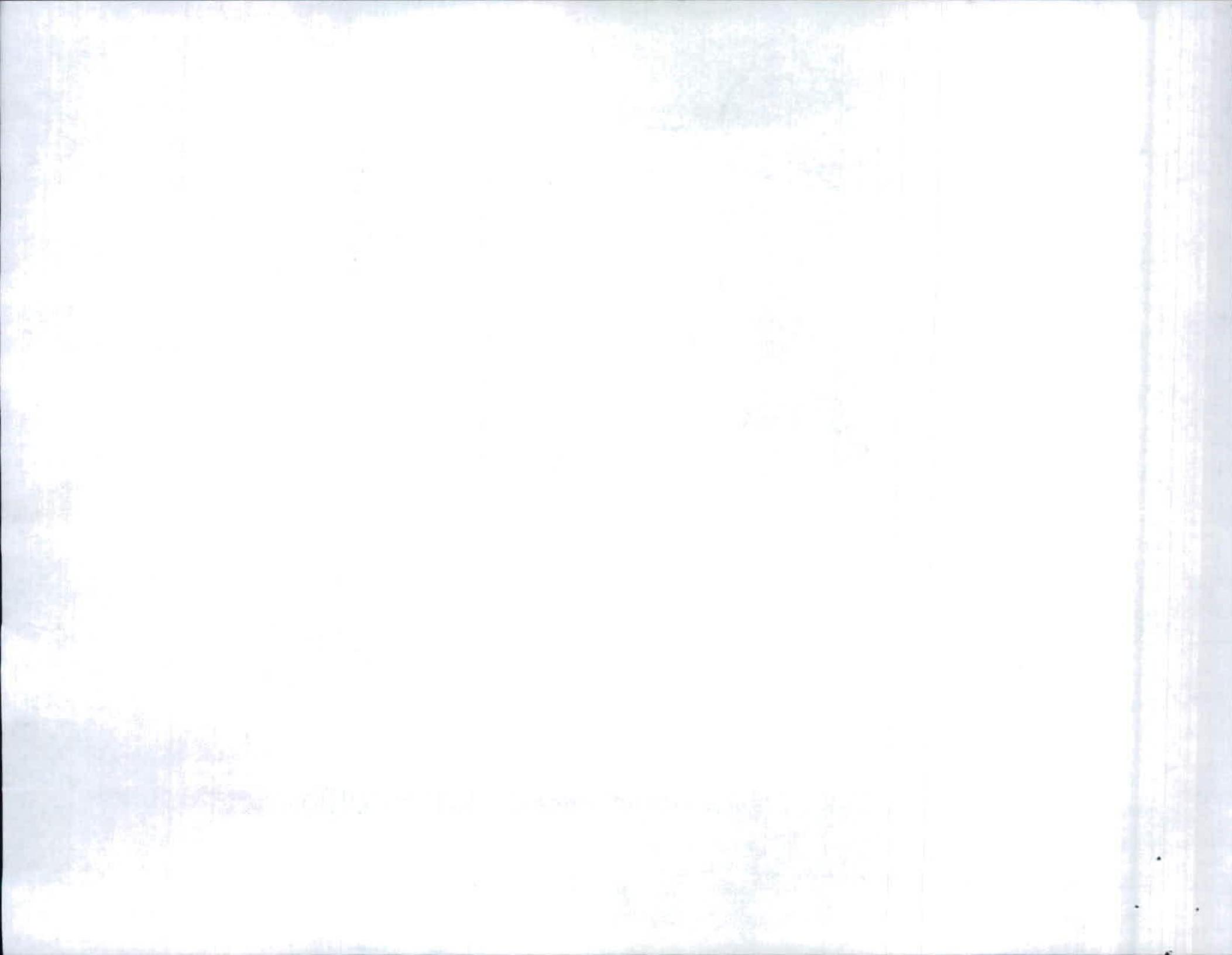
Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg



K 08-08-26



24/07/2008 8:23:49 AM
arie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg



12/08/07/24

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION



12/08/07/25

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



12/08/07/26

9.0 MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

HELICAL INSERT



12/08/07/27

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- tap drill for helical

3- install helical insert as per dwg



12/08/07/28

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



12/08/07/29

12.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1



13.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

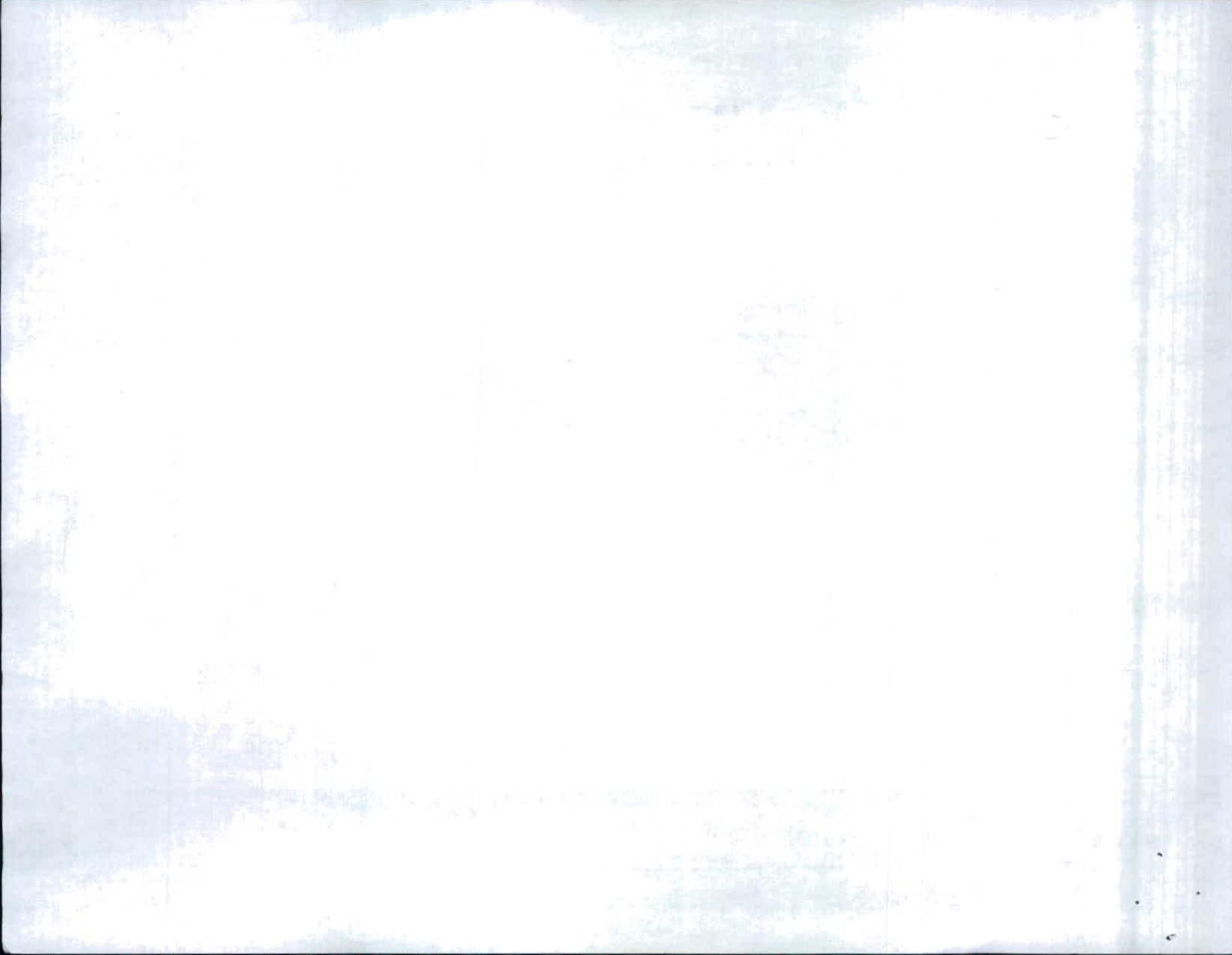


5X

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M-F 08/07/31



Process Sheet

Duplicate
2

| | | | | |
|-----------------------|--|---------------------------|------------------|-----------------------------------|
| Customer | CU-DAR001 | Dart Helicopters Services | Drawing Name | FWD ADJUSTABLE BLADE SUPPORT ASSY |
| Job Number | 40608 | 1A | Part Number | PB674300115 |
| Estimate Number | 13433 | | Drawing Number | B6743001 P.7 |
| P.O. Number | | | Project Number | N/A |
| This Issue | 24/07/2008 | S.O. No. : | Drawing Revision | B1 |
| Prsht Rev. | NC | | Material | : |
| First Issue | 17/07/2008 | Type : | Due Date | 24/07/2008 |
| Previous Run | | | Qty: | 15 |
| Written By | | | Um: | EA |
| Checked & Approved By | MF 08-07-24 | | | |
| Comment | Est Rev:A 08-06-26 new issue DD verified by:ec | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description: | |
|---------|-----------------------|--|--|
| 1.0 | PB6743001257 | Inner Tube | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Inner Tube batch: 40585 | |
| 2.0 | PB6743001249 | Inner Tube Bushing | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Inner Tube Bushing batch: M12141 | |
| 3.0 | PB6743001253 | Gusset | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Gusset batch: B40045 | |
| 4.0 | PB6743001254 | Gusset | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Gusset batch: B40053 | |
| 5.0 | PB674300171 | PB67-43001-71 | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) PB67-43001-71 batch: B40027 | |